

81537

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 15/03/2012 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 29/03/2012 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: 12/03/15 Tooling:

Date:

Run Start *NR1*

QC:

Date: / / **SPC (Y/N):**

Date:

Stop ***NR2***

[illegible]

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 81537

March-15-12 10:30:00 AM

81537

Page 2

Item ID: D3196-4 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 15/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 29/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------------------------|-----------------------------------------------------------------------------------------------|----------------------|---------|----------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | 12/03/29 | | 6 | 0 | | |
| 140 *140* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 6 | 123.29 | | |
| 150 *150* Powdercoat Powder Coating | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 7h15 FINISH TIME: 7h45 | 0.00 0.00 | | | | 6 | 2 | 29 | 12/03/29 30. |
| | | | | m/17 338 | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 81537

81537

Page 3

March-15-12 10:30:00 AM

Item ID: D3196-4 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 15/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 29/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----------------|--------------------------|------|--|--|--|--|--|--|--|
| 160 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

6 BL 123.30.

| | | | | | | | | | |
|--------------|---------------------------------------------|------|--|--|--|--|--|--|--|
| 170 | Identify as per dwg & Stock Location: ST260 | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

(6x) SP 12-03-30.

| | | | | | | | | | |
|-----------------|---------------------------------------------|------|--|--|--|--|--|--|--|
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/4/2

12-03-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

March-15-12 10:30:05 AM

Page 1

Work Order ID: 81537

81537

Parent Item: D3196-4

D3196-4

Parent Item Name: Bar

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-08 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.750X01.50 0 | | Purchased | No | | | 100 | f | 70.1474 | 2.89 | 18.25263 | | | |

M6061T6B0 750X01 500

6061-T6 Bar .750 X 1.50

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------------|----------------|-----------------|
| MAT002 | 4.4 | |
| 116604 | 1.5 | |
| 118182 | 2 | |
| 118844 | 0.786 | |
| 119513 | 0.114 | |
| MAT003 | 65.747368 | |
| 2 A 120961 | 5.747368 | |
| A 121040 | 60 | |

5.25
12.503

OK 12/03/27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|-------------------------------------|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 81537 |
| Description: Bar | | Part Number: | D3196-4 |
| Inspection Dwg: D3196 Rev: C | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|----------------------|------------------|--------|--------|----------------------|----------|
| 34.625 | +/-0.010 | 34.625 | ✓ | | m-tape | |
| 33.650 | +/-0.010 | 33.650 | ✓ | | - | |
| 16.639 | +/-0.010 | 16.639 | ✓ | | - | |
| 0.488 | +/-0.010 | .487 | ✓ | | Vern | sl-1 |
| 0.962 | +/-0.005 | .963 | ✓ | | - | |
| 0.464 | +/-0.010 | .462 | ✓ | | - | |
| 0.504 | +/-0.010 | .502 | ✓ | | - | |
| Ø0.344 | +0.006/-0.001 | .344 | ✓ | | - | |
| Ø0.660 x 100° | +0.008/-0.001 x 0.5° | .660x100° | ✓ | | - | |
| 0.512 | +/-0.005 | .513 | ✓ | | | |
| 0.060 x 45° | +/-0.010 x 0.5° | .065x45° | ✓ | | | |
| 4.750 | +/-0.010 | 4.748 | ✓ | | | |
| 12.531 | +/-0.010 | 12.531 | ✓ | | m-tape | |
| 16.627 | +/-0.010 | 16.627 | ✓ | | - | |
| 21.844 | +/-0.010 | 21.844 | ✓ | | - | |
| 29.625 | +/-0.010 | 29.625 | ✓ | | - | |
| 0.250 | +/-0.010 | .250 | ✓ | | | |
| 1.000 | +/-0.010 | 1.000 | ✓ | | | |
| R0.125 | +/-0.010 | .125 | ✓ | | R-G | |
| 0.987 | +/-0.010 | .988 | ✓ | | | |
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|---------------------|----------|--------------------|----------|------------------------------|--|
| Measured by: | SL | Audited by: | B.A | Preliminary Approval: | |
| Date: | 12/03/28 | Date: | 12/03/29 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------|------------|----------|
| A | 04.04.20 | New Issue | KJ/RF | |
| B | 06.10.24 | Dwg Rev updated | KJ/JLM | |
| C | 11.06.21 | Dwg Rev updated | KJ | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

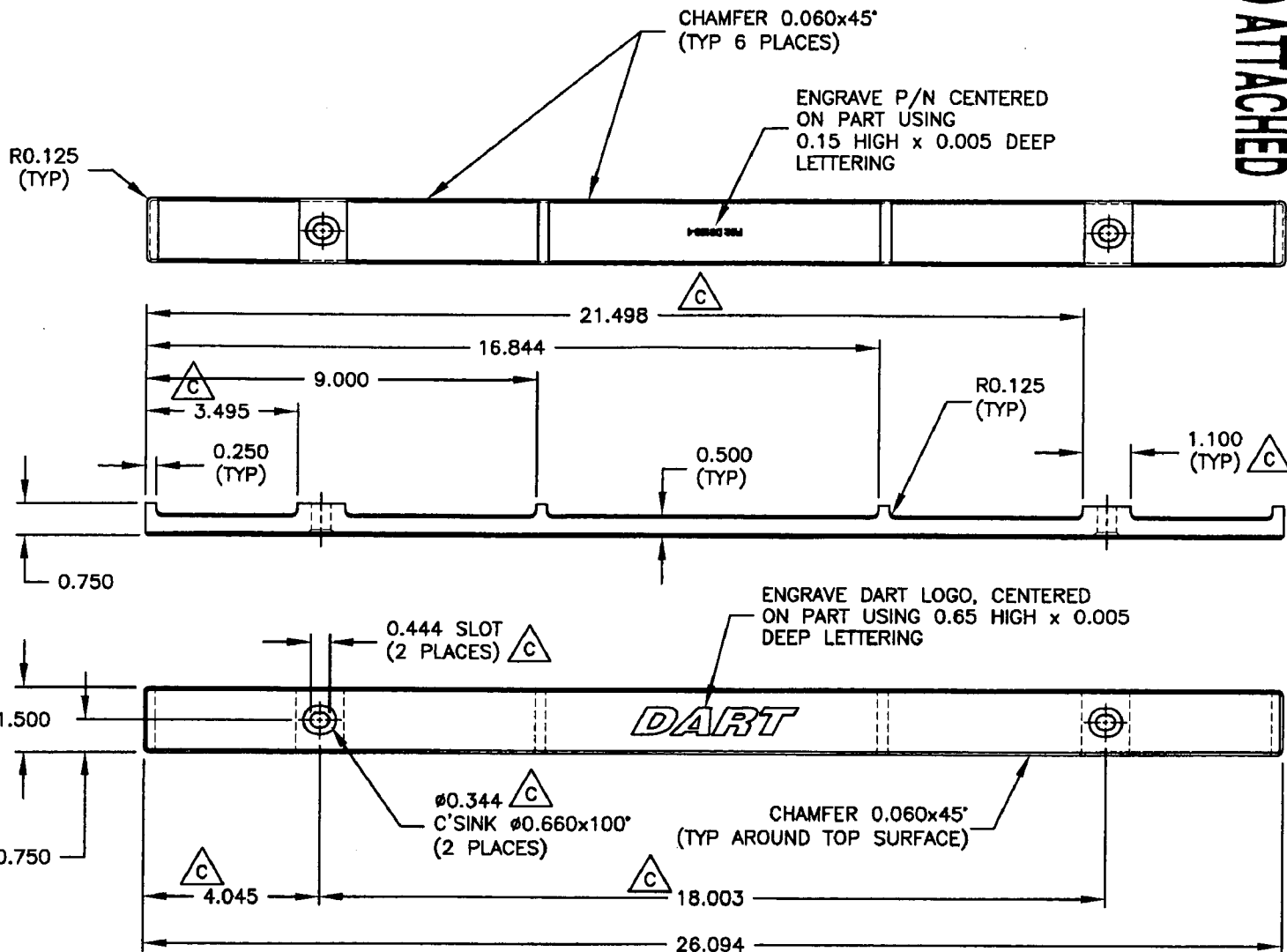
DART

RELEASED

06.10.31

DEO ATTACHED

| DESIGN | DRAWN BY | DART AEROSPACE LTD | REV. C |
|----------|----------|-----------------------------|--------------|
| 90 | JB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | SHEET 1 OF 3 |
| PH | JB | D3196 | |
| DATE | TITLE | SCALE | |
| 06.10.31 | BAR | 1:4 | |
| A | 03.06.25 | NEW ISSUE | |
| B | 06.09.25 | ADD D3196-5 | |
| C | 06.10.31 | ADD SLOTS ON -1; REMOVED -5 | |



D3196-1 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81537 MLJ
12/03/15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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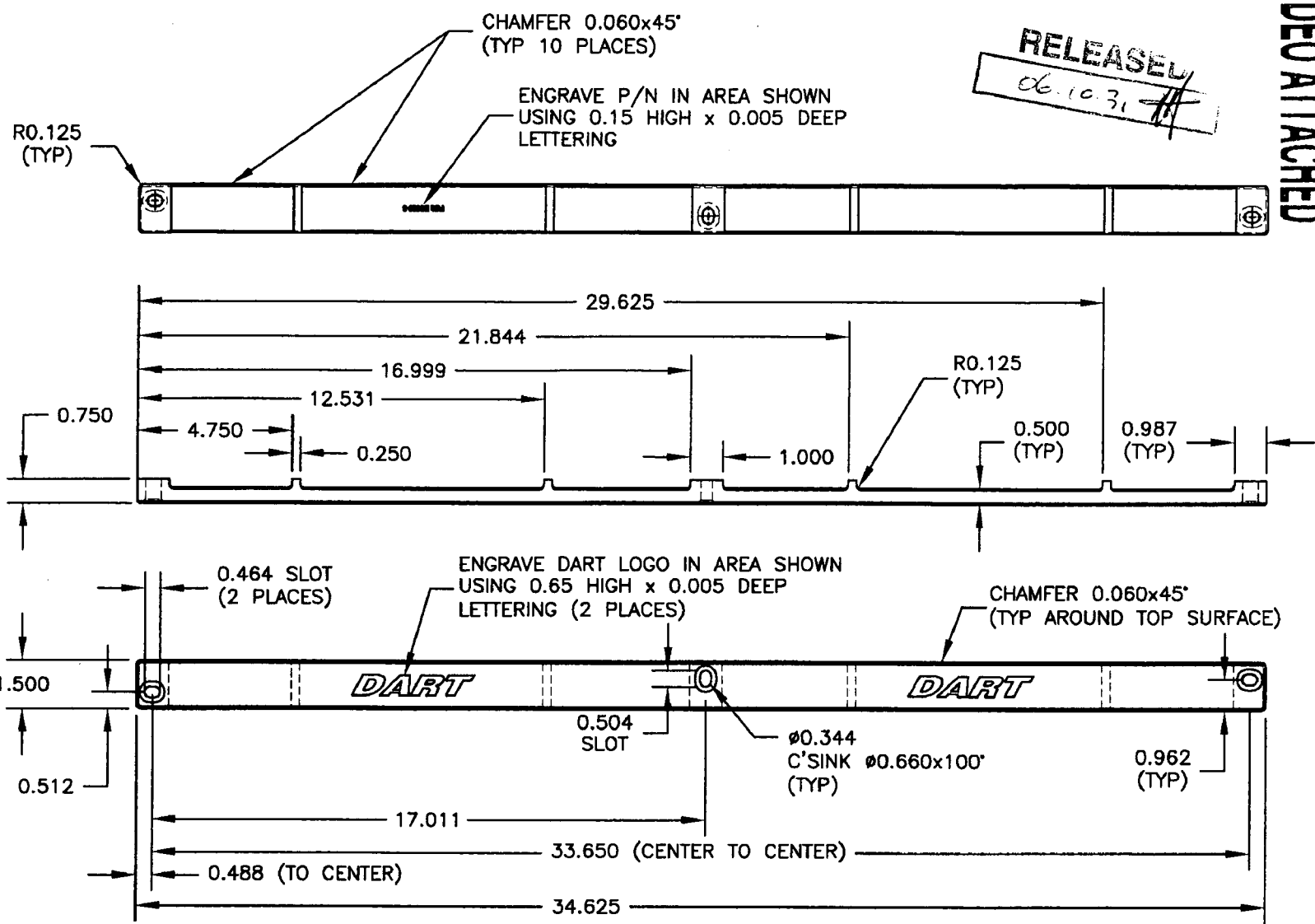
NOTE: Date & initial all entries

81537

DART**DETACHED**RELEASED
06.10.31

| | | | | |
|---------|----------|-------------|--------|-----------------------------|
| DESIGN | QC | DRAWN BY | JD | DART AEROSPACE LTD |
| CHECKED | PH | APPROVED | PH | HAWKESBURY, ONTARIO, CANADA |
| DATE | 06.10.31 | DRAWING NO. | D3196 | REV. C |
| TITLE | BAR | SHEET | 2 OF 3 | SCALE |

1:5

**D3196-3 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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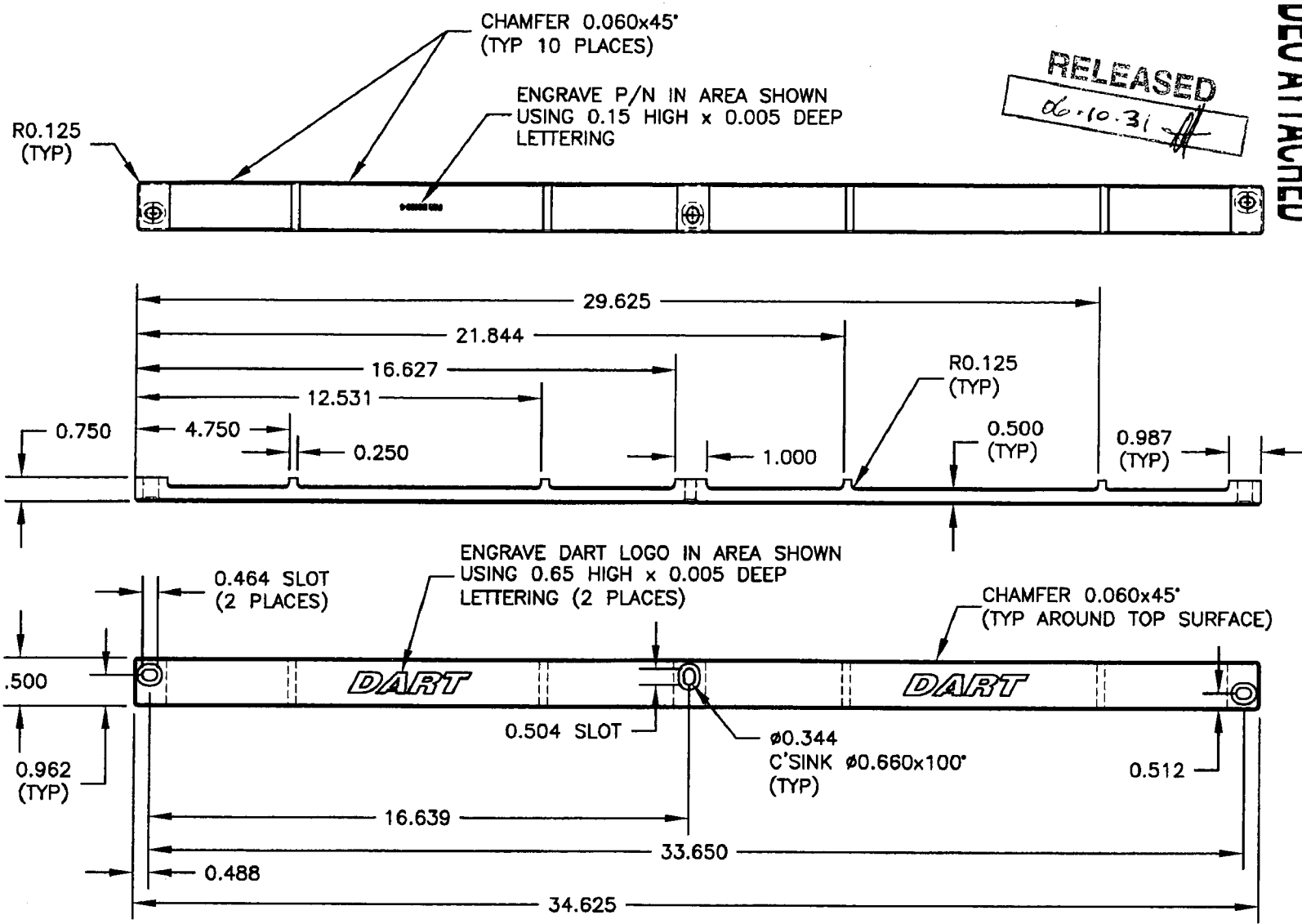
NOTE: Date & initial all entries

81537

DART

DEO ATTACHED

RELEASED
06.10.31



D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

| | | |
|----------|----------|-----------------------------|
| DESIGN | DRN BY | DART AEROSPACE LTD |
| CHECKED | APPROVED | HAWKESBURY, ONTARIO, CANADA |
| DATE | TITLE | REV. C |
| 06.10.31 | BAR | D3196 |
| | | SHEET 3 OF 3 |
| | | SCALE 1:1 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|----------------------|-------------------------------|----------------------------------|-----------------------------------------|--|--------------------------------|---------------------------|--------------|
| DRAWING NO. D3196 | TITLE BAR | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3196-C-1 | SHEET NO. SHEET 1 OF 2 | SCALE NTS |
| DRAWN <i>ASS</i> | CHECKED <i>[Signature]</i> | MFG. APPR. <i>[Signature]</i> | APPROVED <i>[Signature]</i> | | DE APPR. <i>[Signature]</i> | | |
| DATE 08.08.27 | DATE 08.08.28 | DATE 08.08.29 | DATE 08.08.29 | | DATE 08.08.29 | DATE 08.09.04 | |

SHEET 1 MODIFY SLOT DIMENSIONING ON D3196-1 AS SHOWN:

IS:



D3196-1 BAR

WAS:

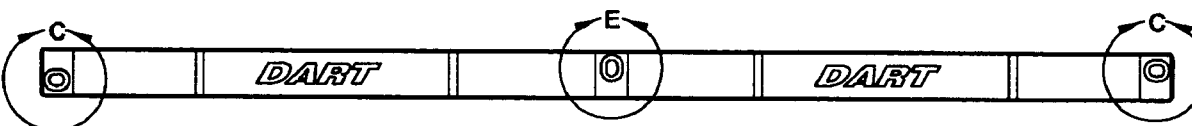


Ø0.344
C'SINK Ø0.660x100°
(2 PLACES)

D3196-1 BAR

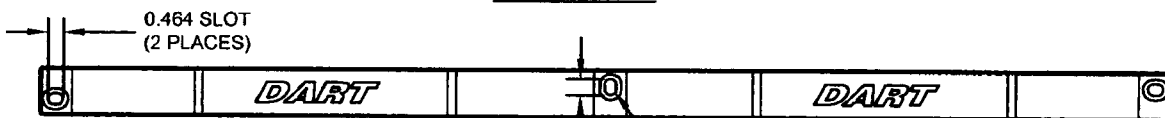
SHEET 2 MODIFY SLOT DIMENSIONING ON D3196-3 AS SHOWN:

IS:



D3196-3 BAR

WAS:



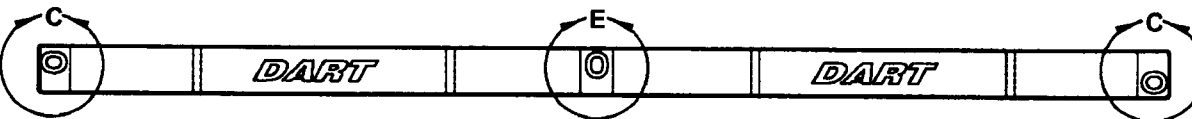
0.504
SLOT

Ø0.344
C'SINK Ø0.660x100°
(TYP)

D3196-3 BAR

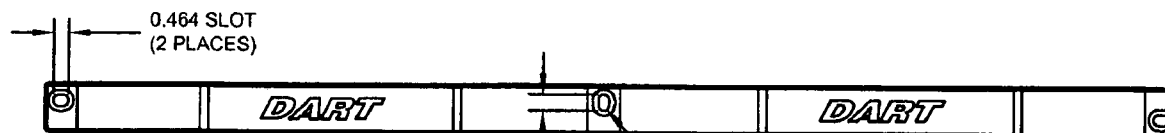
SHEET 3 MODIFY SLOT DIMENSIONING ON D3196-4 AS SHOWN:

IS:



D3196-4 BAR

WAS:



0.504
SLOT

Ø0.344
C'SINK Ø0.660x100°
(TYP)

D3196-4 BAR

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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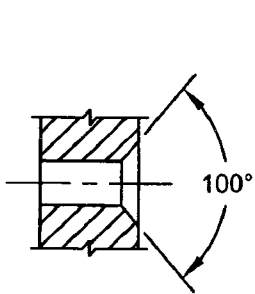
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

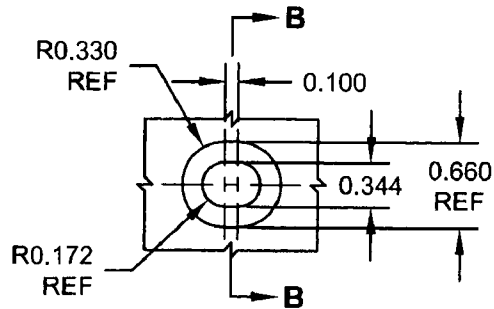
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

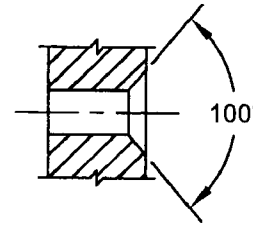
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|----------------------|-------------------------------|----------------------------------|-----------------------------------------|------------------|--------------------------------|---------------------------|--------------|
| DRAWING NO. D3196 | TITLE BAR | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3196-C-1 | SHEET NO. SHEET 2 OF 2 | SCALE NTS |
| DRAWN <i>ASS</i> | CHECKED <i>[Signature]</i> | MFG. APPR. <i>[Signature]</i> | APPROVED <i>[Signature]</i> | | DE APPR. <i>[Signature]</i> | | |
| DATE 08.08.27 | DATE 08.08.28 | DATE 08.08.29 | DATE 08.08.29 | DATE 08.08.29 | DATE 08.09.04 | | |



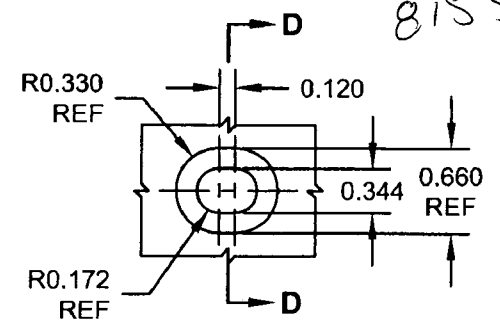
SECTION B-B



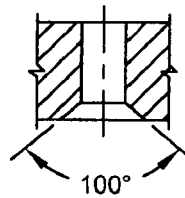
DETAIL A



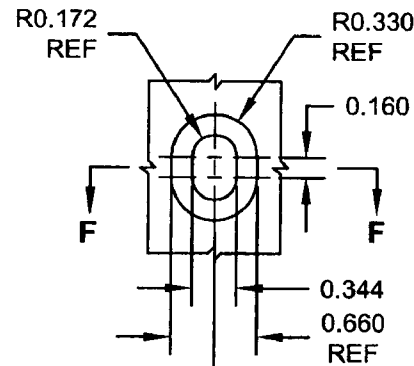
SECTION D-D



DETAIL C



SECTION F-F



DETAIL E

NOTE: THIS CHANGE HAS BEEN DONE TO CLARIFY SLOT DIMENSIONS ONLY. NO CHANGES HAVE BEEN MADE TO THE PARTS
SEE NCR 08-051 FOR FURTHER INFORMATION
ALL OTHER INFORMATION REMAINS UNCHANGED

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries